

Work Order ID 67148

Wednesday, March 09, 2011 12:48:46 PM



Page 1

Item ID: D206-642-311

Accept



Setup Start



Revision ID:

Item Name: Skidtube LH

Stop



Start Date: 3/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: H Date: 11-03-09 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D206-642	Rev N								

100 0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-311 CHG006

Sal6407

110 0.00



Pick Kit

Packaging

Memo

0.00

Packaging

CB 1 11/04/27

120 0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

Sal66107

(4)

B67157

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 12:48:54 PM

Page 1

Work Order ID: 67148

Parent Item: D206-642-311

Parent Item Name: Skidtube LH



Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC
IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec
IPP Rev:L 08-09-29 as per DS19421 DD verified by:EC IPP Rev:M
as per REV.N DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D206-642-341

Manufactured

No

110

Each

3.0000

1

1



Replacement Skidtube



67157

EC

Location

Loc Qty

Loc Code

FG082

3

36550

1

44043

1

44044

1

D206-648-013

CHG003

Manufactured

No

110

Each

0.0000

1

1



GHW Modification

D2932-1

Manufactured

No

110

Each

0.0000

1

1



Saddle LH Out, 206



B67790

JB

JB

D2933-1

Manufactured

No

110

Each

0.0000

1

1



Saddle LH In, 206



B67791

JB

JB

JB 11/04/22

D2938-1

Manufactured

No

110

Each

7.0000

1

1



Saddle LH Out, 206



B69033

11/6/13

11/04/22

Location

Loc Qty

Loc Code

ST421

4

66399

4

ST428A

3

66251

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 12:48:55 PM

Work Order ID: 67148

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D2939-1 Manufactured No

110 Each

0.0000

1

1 ✓



Saddle LH In, 206

AN3-41A Purchased No

110 Each

372.0000

8

8 ✓



Bolt

Location

Loc Qty

Loc Code

ST354

372

112431

1

114941

71

115936

100

116191

200

114941

D2652 Manufactured No

110 Each

229.0000

16

16 ✓



Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

185

65049

64

66124

121

MS21042L3 Purchased No

110 Each

2,376.000

8

8 ✓



Nut

Location

Loc Qty

Loc Code

ST300

2376

116391

776

116540

800

116549

800

116540

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 3

Wednesday, March 09, 2011 12:48:55 PM

Work Order ID: 67148

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD10 NAS1149D0363J Purchased

No

110

Each

24.0000

8

8 ✓



Washer



M 116583 JB

SL

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

18

105792

2

112279

16

AN5-10A

Purchased

No

110

Each

210.0000

4

4 ✓



Bolt



JB

SL

Location

Loc Qty

Loc Code

ST337

210

115589

50

115700

10

116704

50

116924

50

117010

50

AN5-11A

Purchased

No

110

Each

57.0000

4

4 ✓



Bolt



117010

JB

11/04/27 SL

Location

Loc Qty

Loc Code

ST337

55

116419

25

116978

30

ST338

2

115422

2

116419

Wednesday, March 09, 2011 12:48:55 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 12:48:55 PM

Work Order ID: 67148

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD516

NAS1149D0563J

Purchased

No

110

Each

34.0000

8

8 ✓



Washer

M117291 JB

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

AN4-6A

Purchased

No

110

Each

1,418.000

12

12 ✓



Bolt

JB

Location

Loc Qty

Loc Code

ST356

1418

112933

96

113149

17

115108

5

115936

200

116191

300

116400

400

116924

400

116191

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

30.0000

25

25 ✓



Washer

M117065 11/04/21

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 12:48:56 PM

Work Order ID: 67148

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

4,376.000

12

12

✓



Nut

Location

Loc Qty

Loc Code

ST300

4376

1123143

2

115589

10

115621

20

~~116188~~

2344

116823

2000

116188

JB SP

D3407-043

Manufactured

No

110

Each

10.0000

1



Tow Ring

Location

Loc Qty

Loc Code

ST420

8

66386

8

ST464

2

50387

1

64071

1

~~66386~~

68335

JP C

D3456-1

Manufactured

No

110

Each

61.0000

1



Washer

Location

Loc Qty

Loc Code

ST054

61

63239

2

64282

9

66848

50

68748 JB

11/04/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 12:48:56 PM

Work Order ID: 67148

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D3457-1

Manufactured No

110 Each

25.0000

2

2 ✓



Washer

JB SP

Location

Loc Qty

Loc Code

FG	10
32409	10
ST054	15
45913	1
66030	14

66030

MS21043-4

Purchased No

110 Each

823.0000

1

1 ✓



Nut

JB SP

Location

Loc Qty

Loc Code

ST301	823
114523	5
114784	2
116188	516
116549	300

116188

AN4C5A

Purchased No

110 Each

434.0000

1

1 ✓



BOLT

JB SP

Location

Loc Qty

Loc Code

ST346	434
112243	434

112243

AN960C416

NAS1149C0463 R Purchased

No

110 Each

29.0000

1

1 ✓



washer

mill6900 JB 11/04/27

Location

Loc Qty

Loc Code

ST346	29
100993	29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

Wednesday, March 09, 2011 12:48:56 PM

Work Order ID: 67148

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Manufactured No

110 Each

35.0000

1

1

✓



Ring



JB SP

Location

Loc Qty

Loc Code

ST420

23

62961

9

66387

14

~~66387~~

ST473

12

51586

1

53446

1

65294

10

65294

D2712

Manufactured No

110 Each

568.0000

10

10

✓



Set Screw



JB SP

Location

Loc Qty

Loc Code

FG

50

29962

50

ST012

250

66955

250

ST021

268

61331

18

65115

250

65115

D2934

Manufactured No

110 Each

21.0000

2

2

✓



Saddle Spacer



11/04/27 SP

Location

Loc Qty

Loc Code

FG

6

31929

6

ST027

15

66043

15

66043

Wednesday, March 09, 2011 12:48:57 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 8

Wednesday, March 09, 2011 12:48:57 PM

Work Order ID: 67148

Parent Item: D206-642-311

Parent Item Name: Skidtube LH



Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D2935

Manufactured No

110

Each

80.0000

2

2



Saddle Spacer



fb 11/04/27 SP

Location

Loc Qty

Loc Code

ST027

80

63558

9

66564

71

63558

Wednesday, March 09, 2011 12:48:57 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval* QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

Item	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	Part Number	Description
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D2650-5	SKIDTUBE ASSEMBLY
2A			14			D2651-1	* PLUG ⁽¹⁾
2B			14			D2651-3	* O-RING ⁽¹⁾
3			1			D2646	* AFT CAP ⁽¹⁾
4			2			MS27039-1-08	* SCREW ⁽¹⁾
5			2			AN960JD10L	* WASHER ⁽¹⁾
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3-41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21042-3	NUT (OR MS21042L3)
12B	8	8				AN960JD10	WASHER
13	4	4				AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4				AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8				AN960JD516	WASHER
16	12	12				AN4-6A	BOLT
17	24	24				AN960JD416	WASHER
18	12	12				MS21042-4	NUT (OR MS21042L4)
20A			6	6		D3537-1	WEARPAD (REPLACES D2648-3)
21A			1	1		D3537-3	WEARPAD (REPLACES D3429-1)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)
22B			1	1		D3536-11	GASKET
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)
23B			1	1		D3536-23	GASKET
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)
24B			1	1		D3536-35	GASKET
26A			54	54		MS27039C1-08	SCREW
26B			54	54		AN960C10L	WASHER
26C			54			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1				D3456-1	WASHER
32	1	1				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING (REPLACES D2655)
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER
40					2	D3414-041	GHW LUG (REPLACES D2659)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

NOTES: ⁽¹⁾ DENOTES THAT PART IS INCLUDED WITH D2650-5 ASSEMBLY ABOVE⁽²⁾ CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

• COPYRIGHT © 2000 BY DART AEROSPACE USA, INC. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: N

Date: 09.09.09

